

# Work Order ID 51780

Thursday, September 03, 2009 8:14:09 AM



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Item ID:	D3272-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Step					
Start Date:	9/3/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	9/18/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>RL</i>	Date:	<i>09-9-03</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	***SQUARE ONE END BEFORE CUTTING OTHER END***								

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A *09.09.04* *RL*

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. *09.09.08* *RL*

3-Deburr *09.09.09* *RL*

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*2) S 09/09/09*

*(x10)*

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Item ID: D3272-1

Accept

Revision ID: B

Item Name: Step

Setup Start

Stop

Start Date: 9/3/2009 Start Qty: 10.00

Required Date: 9/18/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Identify as per dwg & Stock Location: <u>WA</u>	0.00	<u>09-09-09</u>			<u>10</u>			
Packaging	Memo	0.00							
Packaging									
130 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/09/11 MF  
09-09-09

# Picklist Print

Thursday, September 03, 2009 8:14:24 AM

Work Order ID: 51780



Parent Item: D3272-1RevB



Parent Item Name: Step

Start Date: 9/3/2009

Required Date: 9/18/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120CRevC1		Manufactured	No			100	Each	106.0000	10.0000			
										343612		29.09.07
Step Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

106

48612

106

10

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

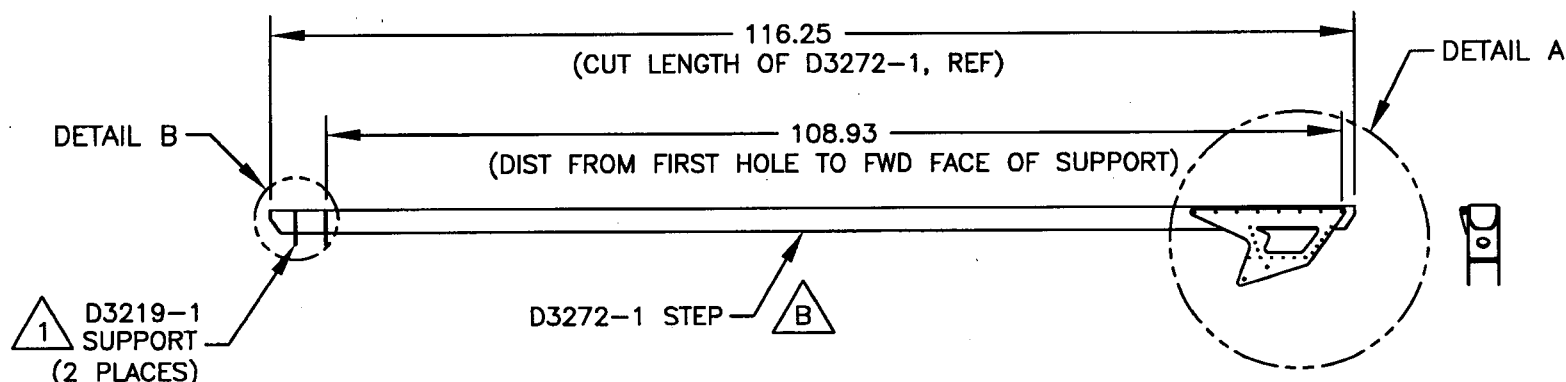
**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

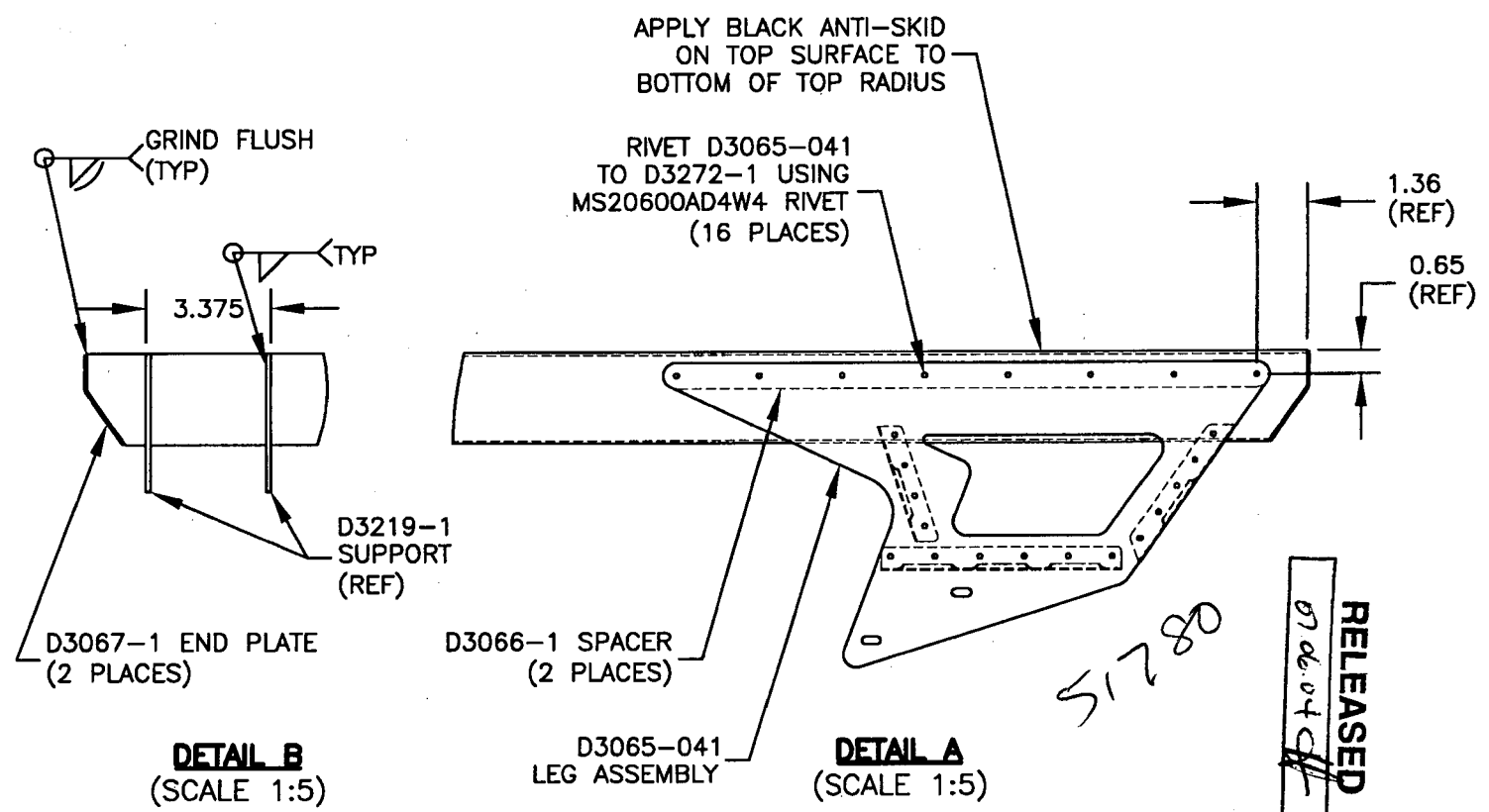
517  
08

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**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



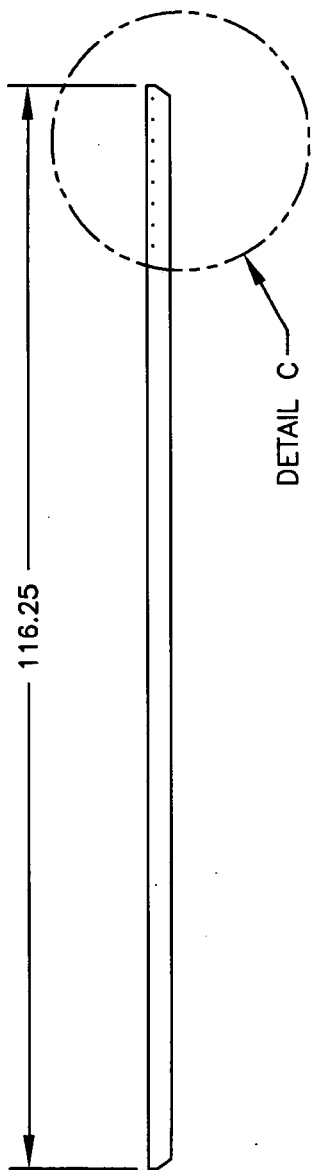
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20

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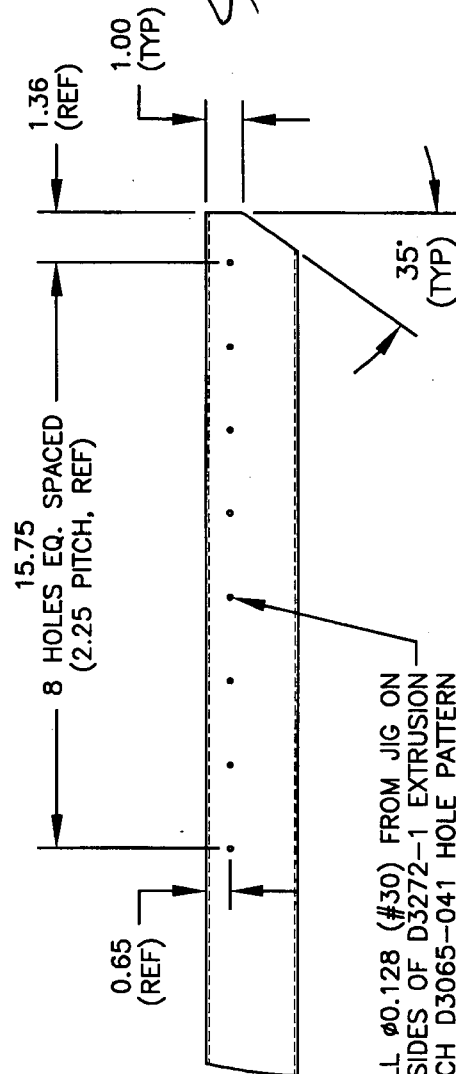
DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

**B** D3272-1 STEP  
(MAKE FROM D2622-120 STEP EXTRUSION)

114.65



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**C**  
(SCALE 1:5)

RELEASED

07.06.04

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